

Work Order ID 146089

146089

Page 1

Tuesday, June 07, 2016 8:14:31 AM

Item ID: D2581 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Mounting Bracket
 Start Date: 5/11/2016 Start Qty: 60.00 *60* Cust Item ID:
 Required Date: 5/16/2016 Req'd Qty: 60.00 *60* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2581	Rev A1

105		0.00							
105									
Purchasing									
Purchasing	5.35								
	Memo	0.00							
	ISSUE PO 32646								
	CUT PER DRWG D2581 REV.A1								

115	Receive & Inspect for Damage & Mat'l Certs	0.00							
115									
Packaging									
Packaging									
	Memo	0.00							

125	QC6- Inspect dimensions to drawing	0.00							
125									
QC									
Quality Control									
	Memo	0.00							

126 w/teget
 Open holes per drwg
 PTO

DQA:

Date:

16.08.29



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16.08.11

Work Order update only ☐

Work Order: <u>146089</u> Part No. <u>D2581</u> NCR No. <u>16-5967</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☒</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☒																																																									
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Description Work Order Deviation				Disposition																																																																											
holes varies from .321 to .341. holes are also oval. R.C. supplier				open hole to drawing (.328") using reamer and deburr. inform findings to supplier *Supplier contacts. 5/16/24																																																																											
								PD 16.06.23 Completed By PR 2016/07/06																																																																							
								Lead hand / Supervisor Approval Verification DAS 38 9-88																																																																							
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Work Order ID 146089

Tuesday, June 07, 2016 8:14:31 AM

146089

Page 2

Item ID: D2581

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Bracket

Start Date: 5/11/2016 Start Qty: 60.00

60

Cust Item ID:

Required Date: 5/16/2016 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.20 1.20				DAS 30 9-89 (60)			JUL 07 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 1.20				(60)			DAS 38 9-89 JUL 11 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo *****STOCK IN BASKET CELL***** LOCATION WA004	0.00 0.60			DAS 8 9-89	(60)		PC	JUL 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

Work Order ID 146089

Tuesday, June 07, 2016 8:14:31 AM

146089

Page 3

Item ID: D2581

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Bracket

Start Date: 5/11/2016 Start Qty: 60.00

60

Cust Item ID:

Required Date: 5/16/2016 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

6.00

Quality Control

DAS
21
9-89

JUL 08 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
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Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Picklist Print

Tuesday, June 07, 2016 8:14:31 AM

Page 1

Work Order ID: 146089

146089

Parent Item: D2581

D2581

Parent Item Name: Mounting Bracket

Start Date: 5/11/2016

Required Date: 5/16/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP D01.07.17Added info to step 2SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581P

Purchased

No

Each

0.0000

60

D2581P

Mounting Bracket

Box 876-6-2h

M304S11GA

Purchased

No

100

sf

107.2349

0.0187

1.181052

M304S11GA

JUL 08 2016

304/316 0.125 Sheet

DAS
13
3-89

Location

Loc Qty

Loc Code

MAT020

80.99998

M129545

31.99998

M129972

23.5

M134284

25.5

TPI

26.234932

M134604

26.234932

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

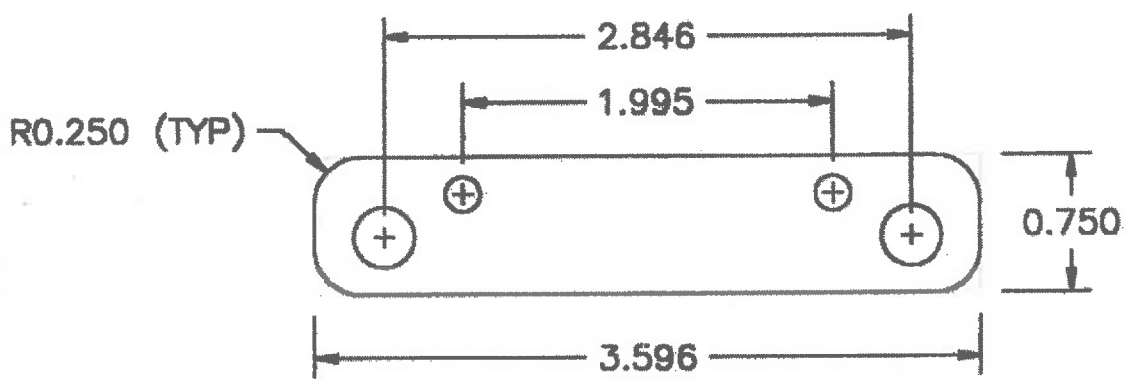
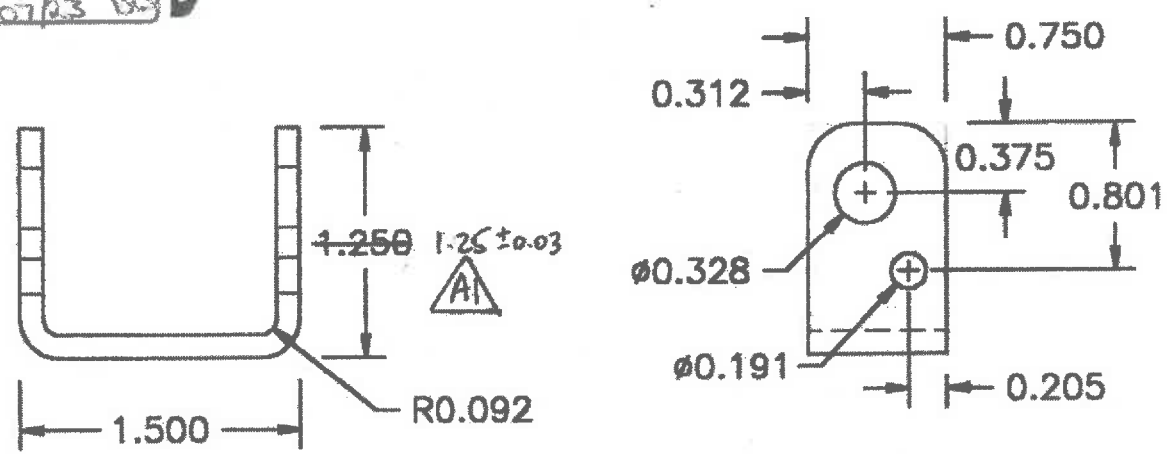
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M	DRAWING NO.	REV. A
CHECKED	APPROVED	D2581	SHEET 1 OF 1
DATE		TITLE	SCALE
96.06.27		MOUNTING BRACKET	1:1
AI	cf 04.05.14	CHANGE TOLERANCE ON 1.25 DIMENSION	

RELEASED
9/6/07/23 B2



MATERIAL: 304/316 SS 0.125 THICK

NO. 146084 MJS
160507
UNCONTROLLED COPY
SUBJECT TO ENGINEERING
WITHOUT NOTICE
DESIGN TO
STAY COPY

DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32646**

Purchase Order Date 6/8/2016

PO Print Date 6/8/2016

Page Number 10 of 12

Order From :

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via: —

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$120.00

25 D2581P

Mounting Bracket

6/22/2016

Yes

6/22/2016

60.00

Each

\$5.35

\$321.00

CUT AS PER DWG D2581 REV. A
B146089
MATERIAL 304 SHEET 11GA

Line Total: \$321.00

26 D4149-1P

Crosstube Lug Plate, Aft

6/22/2016 FN

Yes

6/22/2016

20.00

Each

\$14.75

\$295.00

CUT AS PER DWG D4149 REV. C
B145910
MATERIAL 304 SHEET 11GA

Line Total: \$295.00

Note:

6/8/2016

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.:

7618

Date:

2016-06-17

Page:

1

Sold to:		Ship to:	
Dart Aerospace Chantal Lavoie 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada		Dart Aerospace Chantal Lavoie 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	
Order No.: 32646		Sold By: JONATHAN LESSARD	
Shipped By:		Ship Date:	
Tracking No.:			

Item No.	Unit	Description	Quantity
d3405-1 ✓	Chaque	d3405-1 ✓	✓ 24
d3405-3 ✓	Chaque	d3405-3 ✓	✓ 20
d3912-5	Chaque	d3912-5 eyebolt plate	✓ 24
d4150-3	Chaque	d4150-3 arm plate	24
d4149-1	Chaque	d4149-1 crosstube lug plate aft	32
d2581	Chaque	d2581 mounting bracket	60
d4151-1	Chaque	d4151-1 lower hardpoint plate	10
d4151-3	Chaque	d4151-3 upper hardpoint plate	10

8/16-6-21

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days

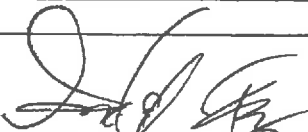
TPI Waterjet cutting follow up sheet

WC100127

machine hours	1162h
diamond hours	112h
mixing tube hours	0h
TAJ calibration	13-06-2016

customer po	part #	Qty	lot #	date done	cut by	quality spot check	Note
dart 32646	D3405-1	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D3405-3	20	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D3912-5	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4150-3	24	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4149-1	32	see mill test	14-06-2016	GR	Jonathan Lessard Gabriel Rioux	test approve by Eric Downing change hole size of .252 to .25
dart 32646	D2581	60	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	D4151-1	10	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	test approve by Eric Downing change hole size of .252 to .25
dart 32646	D4151-3	10	see mill test	15-06-2016	GR	Jonathan Lessard Gabriel Rioux	change hole size of .252 to .25

Opérateur



Superviseur

